

Work Order ID 70687 *Split-2*

Monday, June 13, 2011 1:32:22 PM



Page 1

Item ID: D3537-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run

Start



Approvals: Process Plan:

Date: *110-6-13*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304.063

0.00

B11-6-15

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

B11-6-15

120



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

0.00

Sulxelis

Counts

+60

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM



Page 2

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Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

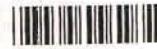
Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2- Identify as D3537-1

140



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M118453 1-Weld as per Dwg D3537 using Jig DT 8210. 2-Remove any
 weld that penetrated through Wearpadif necessary

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM



Page 3

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Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

Sulogzy

0.00

#18



QC

Memo

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

18x Ø M-11/08/26



Powdercoat

Memo

Powder Coating

START TIME:

9:45 0.00

OVEN TEMPERATURE:

320°F

10°15

180

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

18 BR 11-8-25.

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM



Page 4

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Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

190



Packaging

Identify as per dwg & Stock Location

EP/16

Set Up/
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.
Stamp

0.00

18

BL

11-8-25

Packaging

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/18/25 J

C 11/08/25

Picklist Print

Monday, June 13, 2011 1:32:28 PM

Page 1

Work Order ID: 70687



Parent Item: D3537-1

Parent Item Name: Wearpad

Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	119.1000	0.106	5.578947	 Bil-679		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	119.1	
117275	4.3	
117653	114.8	17653

DART AEROSPACE LTD	Work Order:	74537
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>HS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-6-14</u>	Date: <u>11/06/14</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

07.04.13
RELEASER
D3537-1

UNCONTROLLED DOCUMENT

SUBJECT TO AMENDMENT

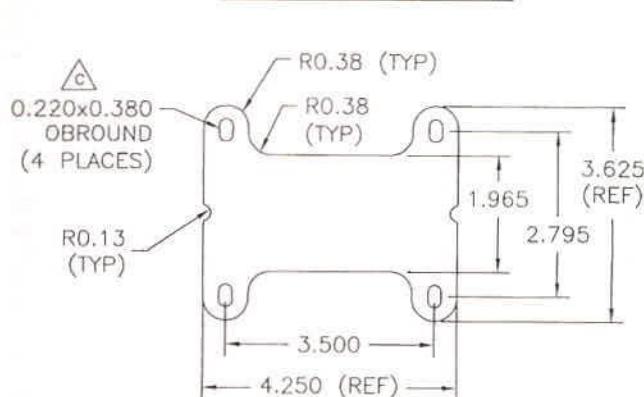
WITHOUT NOTICE

WORK ORDERS

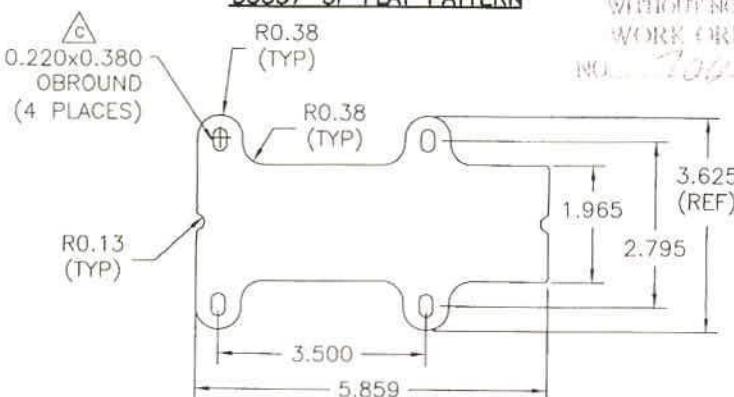
NO. 7346

PLATE 1

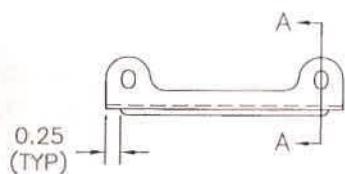
D3537-1F FLAT PATTERN



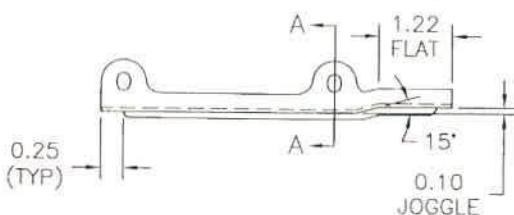
D3537-3F FLAT PATTERN



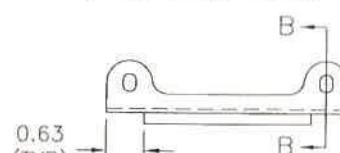
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HUENEMER, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE 1:2

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07.05.08 AM
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